

# Work Order ID 72594

Wednesday, August 03, 2011 1:01:20 PM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 8-08-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

*N/A* *[Signature]*

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,  
use bending aid DT9632  
2- cut fwd end of tube as per dwg

*1* *[Signature]* *BEU/08/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Cut Aft end using DT8185								
	2-Deburr ends								
	3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***								
	4-Locate DT 8973 & Drill Ground wire hole on top of Tube.								
	5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.								
	6-Drill pilot holes for wearplates using DT8900								
	7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.								
	8- open ground wear holes to 0.391" as per section B-B								
	9-Open Aft Cap holes using .209" drill.								
	10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.								

DL 11/08/10

DL 11/08/11

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				x1			Dh
	Hand Finishing								11/08/15
180	QC3- Inspect Part Finish	0.00							
	QC	0.00							DP
	Quality Control								11-8-15

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



Skidtube

Skidtube

Skidtube

Memo

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 &amp; QSI 015

A/R 241 Sike Flex Batch: 1117516  
Exp Date: 12/01/15

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: 1112860

6-Grind welds flush

200



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

} DL 11/08/15

BE 11/08/16

Sulos 117

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sulos/17*



215

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Touch-up alodine as per QSI

*IX Ø M-11/08/23*

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE:

FINISH TIME:

*12:00*  
*320°F*  
*12:30*

*IX Ø M-11/08/23*

*M11745*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BK 11-8-25

250

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BK 11-8-25

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 118393  
Exp Date: 12-5

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see  
section D-D of dwg D3582

\*\*\*\*\*Do not install bolts where indicated on Dwg(Note #6)\*\*\*\*\*

A/R 241 Sika Flex Batch: 118393  
Exp Date: 12-5

4-assemble o-ring as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 118348

5- Wing Walk as per Dwg D3582 and QSI 005 4.4

118313

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

8/11/08/76



QC

Memo

0.00

Quality Control

(40)

270

Packaging

0.00

RR 72493



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-762-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

u/s/bc sp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/s/bc sp

WUF

11-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 72594

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube





Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 07.06.11 New Issue EC  
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-11  Plug		Manufactured	No			250	Each	18.0000	2	2			
<div> <div>Location</div> <div>FP</div> <div>71863 ✓</div> </div> <div> <div>Loc Qty</div> <div>18</div> <div>18</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3492-13  Plug		Manufactured	No			250	Each	35.0000	6	6			
<div> <div>Location</div> <div>FP</div> <div>71848 ✓</div> </div> <div> <div>Loc Qty</div> <div>32</div> <div>32</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>FP-B</div> <div>46693</div> </div> <div> <div>3</div> <div>3</div> </div> <div> <div></div> <div></div> </div>													
D3492-9  Plug		Manufactured	No			250	Each	25.0000	2	2			
<div> <div>Location</div> <div>FP-A</div> <div>46694 ✓</div> </div> <div> <div>Loc Qty</div> <div>25</div> <div>25</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2962-150  3.540 Outer Tube, Extrut		Manufactured	No				Each	62.0000		1			
<div> <div>Location</div> <div>HALL</div> <div>59934</div> </div> <div> <div>Loc Qty</div> <div>62</div> <div>62</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

BR 11-8-26

BR 11-8-26

BR 11-8-26

BB 11/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2964 Manufactured No 140 Each 11.0000 1 1



Cap



*BE 11/08/11*

Location

Loc Qty

Loc Code

LG002

11

64654

11

D2971 Manufactured No 190 Each 6.0000 1 1



Cross Bolt Spacer



*BE 11/08/10*

Location

Loc Qty

Loc Code

LG001

6

44445

6

D3584-1 Manufactured No 190 Each 0.0000 1 1



Web



*Dh  
11/08/15*

D2973 Manufactured No 190 Each 112.0000 2 2



Cross Bolt Spacer



*BE 11/08/10*

Location

Loc Qty

Loc Code

LG002

112

14636

112

D3662-3 Manufactured No 190 Each 7.0000 1 1



Crossbolt Spacer



*BE 11/08/10*

Location

Loc Qty

Loc Code

LG001

7

44456

7

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Shop Packet Print

Page 2

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Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3662-1 Manufactured No

190 Each

3.0000

3

3



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

3

71799

1

72258

2

ALS4-1032-130 Purchased No

Each

2,486.000

36



Insert

Location

Loc Qty

Loc Code

ST281

432

117331

8

118386

424

ST282

2054

117717

54

118237

1744

118312

256

ALS4-428-165 Purchased No

Each

501.0000

2



Inserts

Location

Loc Qty

Loc Code

FP

483

117769

483

FP-B

18

114172

18

D2965 Manufactured No

250

Each

0.0000

1

1



Cap, 105 Skidtube

71371



1

BR 11/08/16  
B 71857 x3

BR 11-8-26

36

BR 11-8-26

2

BR 11-8-26

W/O:		WORK ORDER CHANGES					
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Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3  
Wearplate

Manufactured No

250 Each

1.0000

1

1



BR 11-8-26

Location

Loc Qty

Loc Code

FP021

72169

1

1

38527

1

D3508-9  
Wearplate

Manufactured No

250 Each

0.0000

1

1



BR 11-8-26

72203

D3558-3  
Gasket

Manufactured No

250 Each

11.0000

1

1



BR 11-8-26

Location

Loc Qty

Loc Code

FP014

11

71651

1

72170 ✓

10

D3558-9  
Gasket

Manufactured No

250 Each

10.0000

1

1



BR 11-8-26

Location

Loc Qty

Loc Code

FP014

10

71212 ✓

10

D3558-11  
Gasket

Manufactured No

250 Each

11.0000

1

1



BR 11-8-26

Location

Loc Qty

Loc Code

FP014

11

72202 ✓

11

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Shop Packet Print

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Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-13

Manufactured No

250 Each

15.0000 1 1



Gasket



BR 11-8-26.

Location

Loc Qty

Loc Code

FP014

15

59558 ✓

15

1

D3508-11

Manufactured No

250 Each

10.0000 1 1



Wearplate



BR 11-8-26.

Location

Loc Qty

Loc Code

FP016

10

72011 ✓

10

1

D3508-13

Manufactured No

250 Each

5.0000 1 1



Wearplate



BR 11-8-26.

Location

Loc Qty

Loc Code

FP016

5

71027 ✓

5

1

AN960JD10L

NAS1149D0332J

Purchased

No

250 Each

0.0000 2 2



Washer



117087

2

BR 11-8-26.

Wednesday, August 03, 2011 1:01:35 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 1:01:35 PM

Page 6

Work Order ID: 72594

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

250

Each

1,894.000

28

28



BOLT



*Bl 11-8-26*

Location

Loc Qty

Loc Code

ST350

*118608*

1894

*28*

117313

2

117688

167

117795

163

117872

22

118012

500

118112

40

118451

1000

AN3C5A

Purchased

No

250

Each

1,459.000

2

2



Bolt



*Bl 11-8-26*

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1452

116419

28

116549

42

117343 ✓

500

*2*

117764

300

117872

82

118451

500

Wednesday, August 03, 2011 1:01:35 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Wednesday, August 03, 2011 1:01:35 PM

Work Order ID: 72594

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No

250

Each

19.0000

2

2



Washer

Location

Loc Qty

Loc Code

FP-B

17

110153 ✓

17

ST298

2

110153

2

AN960C10L NAS1149C0332R Purchased No

250

Each

0.0000

28

28



washer

118306

AN4-4A Purchased No

250

Each

70.0000

2

2



Bolt

Location

Loc Qty

Loc Code

FP-B

24

114615 ✓

24

ST356

46

114615

46

NAS1611-012 Purchased No

250

Each

90.0000

6

6



O-RING

Location

Loc Qty

Loc Code

FP

80

118384 ✓

80

FP-A

10

113845

10

BR 11-8-26.

2

BR 11-8-26.

28

BR 11-8-26.

2

BR 11-8-25.

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 1:01:35 PM

Page 8

Work Order ID: 72594

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

131.0000

2

2



O-RING

BR 11-8-26.

Location

Loc Qty

Loc Code

FP-A

131

115101

85

116081 ✓

46

2

NAS1611-016

Purchased

No

250

Each

84.0000

2

2



O-RING

BR 11-8-26.

Location

Loc Qty

Loc Code

FP-A

84

112492 ✓

58

113524

26

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 O-RING  
(SEE TABLE)

### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72594

11-08-3

RELEASED  
2011-05-30

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -048/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JFZ	DRAWING NO.	REV. D
MFG. APPR.	JFZ	D3492	SHEET 1 OF 2
APPROVED	JFZ	TITLE	SCALE
DE APPR.	JFZ	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

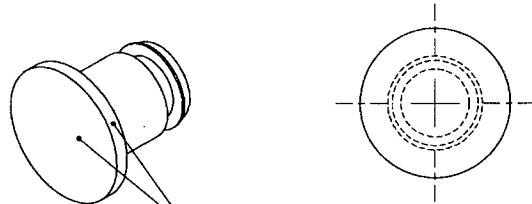
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

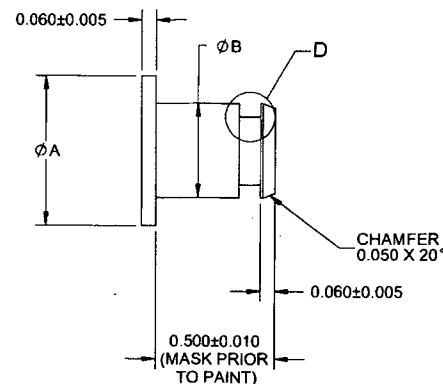
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

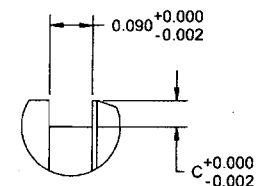
**NOTE:** Date & initial all entries



POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
2011-05-30

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	<b>D3492</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>PLUG</b>	4:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

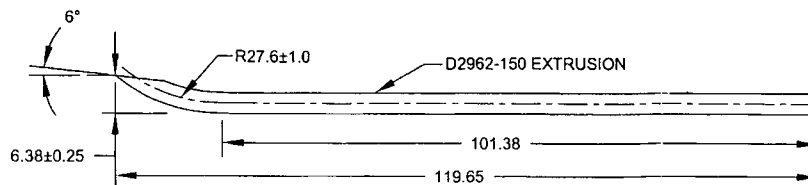
**NOTE:** Date & initial all entries

# PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

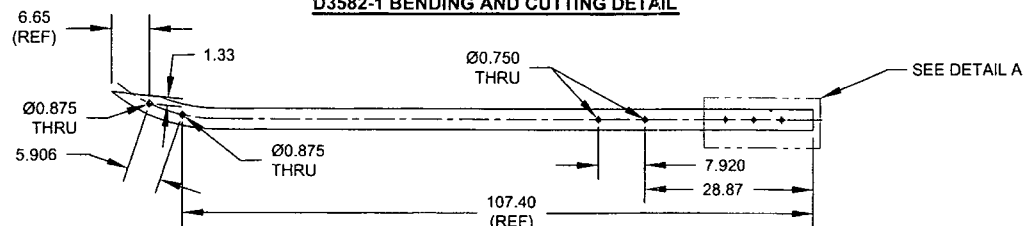
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

## GENERAL NOTES:

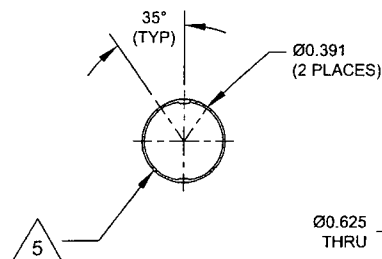
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
  - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
  - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
  - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



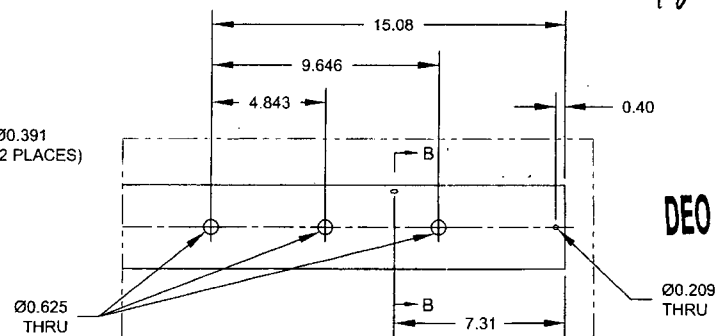
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B  
SCALE 1:5



DETAIL A  
SCALE 1:5

DEO ATTACHED

RELEASED  
07.11.22

A	NEW ISSUE		PH	07.06.08
REV.		DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA  DRAWING NO. D3582  TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	
DRAWN	PH		SHEET 1 OF 2	
CHECKED	PH		SCALE	
MFG. APPR.	PH		1:20	
APPROVED	PH		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
DE APPR.	PH		THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	07.06.08			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

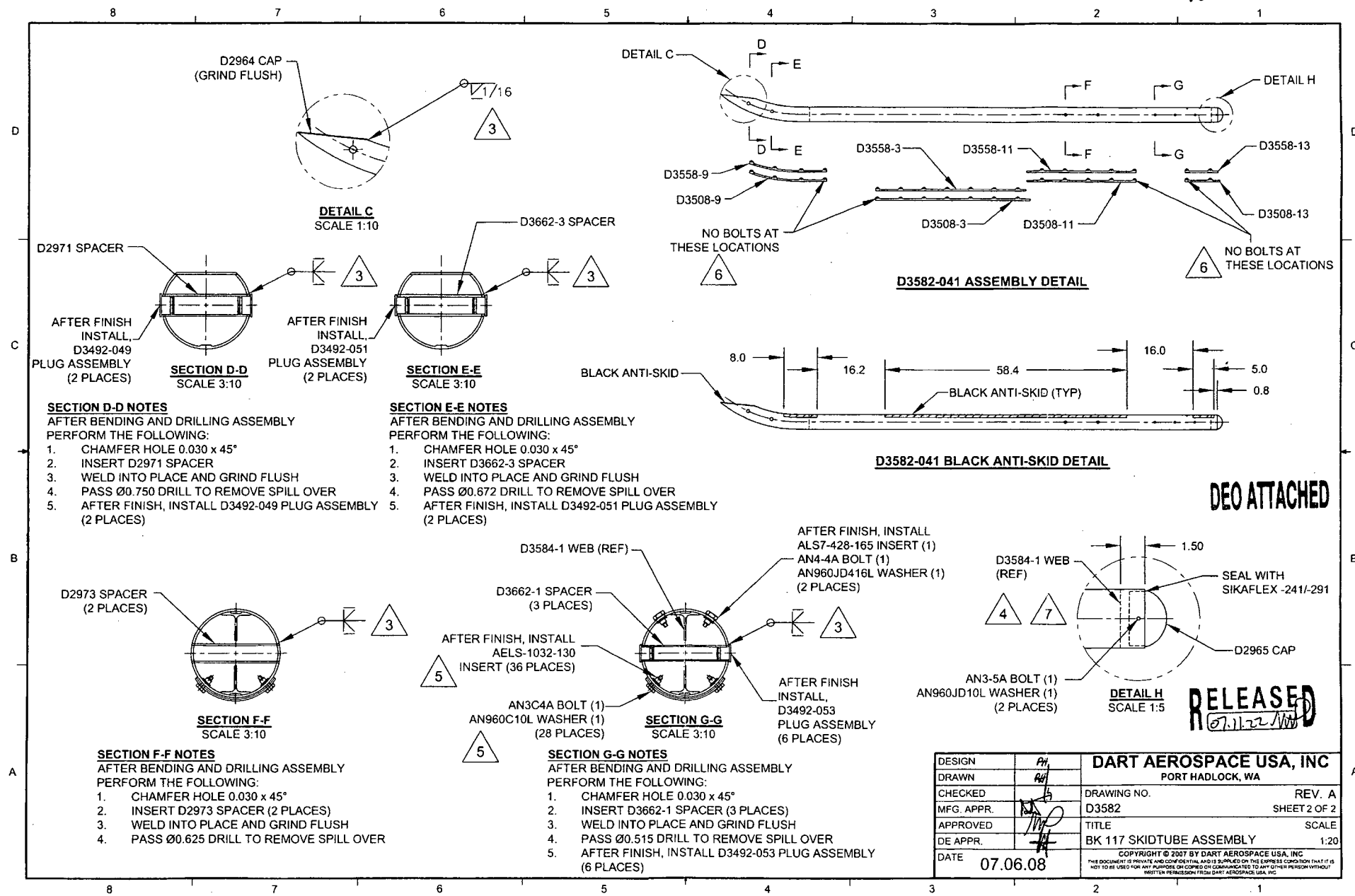
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

12594



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

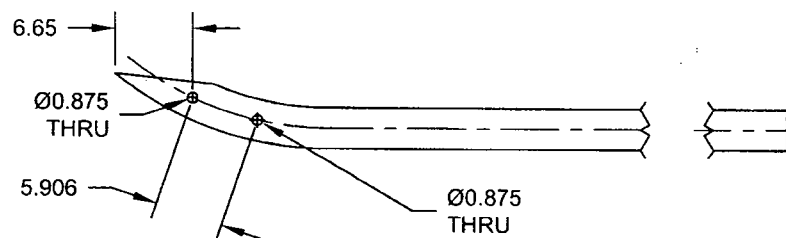
**NOTE:** Date & initial all entries



DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>B</i>	MFG. APPR. <i>B</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

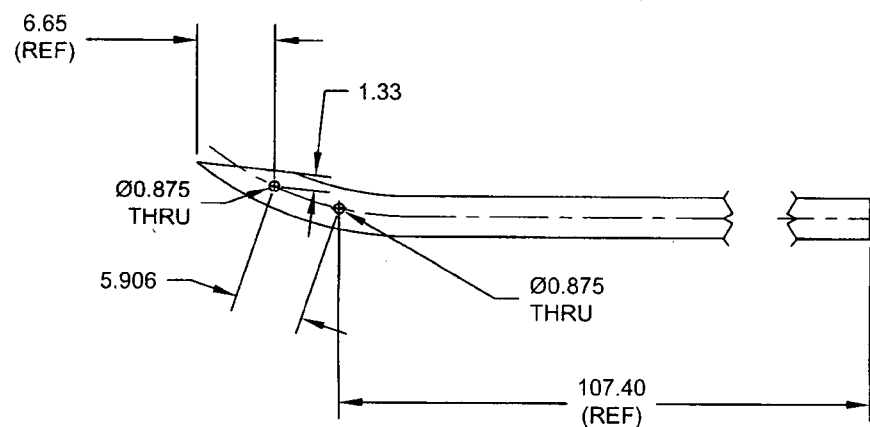
FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:  
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



72594

WAS:



**RELEASED**  
09/04/22 *MD*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 263

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B72595  
Part number: 5117 762 041  
Description: 117  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lucas Date of Test Coupon 11-08-17  
Welder Barclay Elliott Date of Test Coupon 11-08-17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld